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JUN 21 2018

D206-642-311
Job Sheet 178927



Part No: D206-642-311

Job Qty: 1 ea

Part Name: Skidtube LH, Low & High Gear with Standard Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV Q SHEETS 29-30 IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M as per REV.N DD 10.04.19 verified by:EC IPP Rev:N 12.11.21 ECN12-679 DD verf.JLM IPP Rev:O 14.04.25 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	1 Ea		7/6/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs		7/6/18	0.00	0.00	Packaging1-2		
120	QC	1 pcs		7/6/18	0.00	0.00	QC4		
130	Packaging	1 pcs		7/6/18	0.00	0.00	Packaging3-1		
135	DC	1 pcs		7/6/18	0.00	0.00	DC		
140	QC21-FG	1 Ea		7/6/18	0.00	0.00	QC21		

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-311 Location : FG083

135 - Document Control Photocopy bluefile and create labels per PPP D206-642-311 CHG008

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	5038750
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5038982
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5019407
AN5-10A	Bolt	4 Ea (4 ea)	90-Start up Operation	5019407
AN5-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5003927
AN5-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	5003926
D206-642-341	Replacement Skidtube (Fits LH or RH)	1 Ea (1 ea)	90-Start up Operation	5167714
D206-648-013	Ground Handling Wheel Modification	1 Ea (1 ea)	90-Start up Operation	5071820
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	5058607
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5031303
D2932-1	Saddle LH Out, 206	1 Ea (1 ea)	90-Start up Operation	5096747
D2933-1	Saddle LH In, 206	1 Ea (1 ea)	90-Start up Operation	5078926
D2934	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5059584
D2935	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5059582
D2938-1	Saddle LH Out, 206	1 Ea (1 ea)	90-Start up Operation	5071668
D2939-1	Saddle LH In, 206	1 Ea (1 ea)	90-Start up Operation	5079301
D3407-043	Tow Ring	1 Ea (1 ea)	90-Start up Operation	507159457



Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____			Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____			Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
			Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	Approval
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Description Work Order Deviation	Disposition

Root Cause			FAULT CATEGORY		
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Poor	Wrong
Design	Operator	Bending	Set-up	Fold	Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grinding	Tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Direct
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due	OTHER :			

D3413-1	O-Ring
D3456-1	Washer
D3457-1	Washer
MS21042L3	Nut
MS21042L4	Nut
MS21043-4	Nut
NAS1149C0463R	Washer
NAS1149D0363J	Washer
NAS1149D0463J	Washer
NAS1149D0563J	Washer

1 Ea (1 ea)	90-Start up Operation
1 Ea (1 ea)	90-Start up Operation
2 Ea (2 ea)	90-Start up Operation
8 Ea (8 ea)	90-Start up Operation
12 Ea (12 ea)	90-Start up Operation
1 Ea (1 ea)	90-Start up Operation
1 Ea (1 ea)	90-Start up Operation
8 Ea (8 ea)	90-Start up Operation
24 Ea (24 ea)	90-Start up Operation
8 Ea (8 ea)	90-Start up Operation

5068698
5049335
5035435
5018167
5062378
5062290
5052953
5015267
5062379
5068662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	219	0
	AN4-6A	12	1,368	0
	AN4C5A	1	75	0
	AN5-10A	4	155	0
	AN5-11A	8	175	0
	AN5-12A	4	388	0
	D206-642-341	1	3	0
	D206-648-013	1	6	0
	D2652	16	501	0
	D2712	10	739	0
	D2932-1	1	2	0
	D2933-1	1	2	0
	D2934	2	72	0
	D2935	2	54	0
	D2938-1	1	2	0
	D2939-1	1	2	0
	D3407-043	1	24	0
	D3413-1	1	44	0
	D3456-1	1	337	0
	D3457-1	2	29	0
	MS21042L3	8	1,881	0
	MS21042L4	12	2,959	0
	MS21043-4	1	728	0
	NAS1149C0463R	1	253	0
	NAS1149D0363J	8	2,225	0
	NAS1149D0463J	24	5,122	0
	NAS1149D0563J	8	2,091	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date: _____	Step #: _____	QTY Effective: _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____					
Misidentified ☐	Past Due ☐						

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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